

CLAIMS :

1. A synchronization device for a change speed gear, comprising at least one cone clutch which comprises a double cone ring which is freely rotatable relative to a hub between an inner friction ring and an outer synchronizing ring which is axially displaceable relative to the friction ring and which comprises a ring body with a stop gearing on the outer circumference and a friction surface on the inner circumference as well as radially inwardly facing drivers for the friction ring, characterized in that the drivers (13) are provided on a driver ring (16) made of at least one sheet-metal pre-cut part which is joined to the ring body (15) consisting of a sintered body.
2. A synchronization device according to claim 1, characterized in that the driver ring (16) is joined to the ring body (15) by sparing radial gaps (18) distributed over the circumference.
3. A synchronization device according to claim 2, characterized in that the ring body (15) or the driver ring (16) comprises connecting noses (19) determining the gap width.
4. A synchronization device according to claim 2 or 3, characterized in that the gap width corresponds to a thickness of bonding layer provided merely in the circumferential sections.